

Work Order ID 146503

Wednesday, May 18, 2016 9:12:48 AM

146503

Page 1

Item ID: D3915-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Light Lid Assembly, Long Basket

Start Date: 5/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/1/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAY 18 2016

Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3915

E

100

Weld per dwg A/R Aluminum rod Batch: B134926
Large Fab***100***

2.28

Large Fab

Large Fab

Memo

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

1x 16-12-20

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

1 16-12-20DAS
18
9-89

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Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 5/18/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Memo

0.02

Quality Control

DAS

9

9-89

① 16-12-21

130	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

130

HandFinish

Memo

0.88

Hand Finishing

ENSURE TO RINSE CAREFULLY ACID AND ALODINE

①

16-12-21

2016/12/21

BER

140	Weld per dwg A/R Aluminum rod Batch: <u>3134826</u>	0.00							
-----	---	------	--	--	--	--	--	--	--

140

Large Fab

Memo

0.52

Large Fab

1- weld (4) corners

14 16-12-23

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146503

Page 3

Item ID: D3915-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Light Lid Assembly, Long Basket**Start Date:** 5/18/2016 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 6/1/2016 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

① 16-12-23

DAS
9
9-89

155

QC6- Inspect dimensions to drawing

0.00

155

QC

Memo

0.00

Quality Control

① 16-12-23

DAS
9
9-89

inspect fit of lid with base

157

Chemical Conversion Coat per QSI005 4.1

0.00

157

HandFinish

Memo

0.82

Hand Finishing

1- realodine corners
do not acid etch

① 16-12-23

2017/01/03
BEB

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Item ID: D3915-041 **Accept** ***N900040100*** **Setup** **Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 5/18/2016 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 6/1/2016 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Assemble as per dwg	0.00							
180									
HandFinish	Memo	1.12							
Hand Finishing	1- Install webbing as per dwg								
	2- Install placard and label as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.02							
Quality Control									
200	Identify as per dwg & Stock Location: <u>wlc</u>	0.00							
200									
Packaging	Memo	0.01							
Packaging									

DAS
9
9-89

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Item ID:	D3915-041	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Light Lid Assembly, Long Basket					
Start Date:	5/18/2016	Start Qty:	1.00	*1*	Cust Item ID:	
Required Date:	6/1/2016	Req'd Qty:	1.00	*1*	Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210							DAS 21 9-89		
QC	Memo	0.10							JAN 06 2017
Quality Control							DAS 21 9-89		JAN 05 2017

Picklist Print

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Work Order ID: 146503

146503

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 5/18/2016

Required Date: 6/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957 *D2957* Mounting Plate		Manufactured	No			100	Each	45.0000	4	4		DEC 20 2016	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			45					
					137718			15					
					138993			30					
D3915-1 *D3915-1* Rib		Manufactured	No			100	Each	4.0000	2	2		DEC 20 2016	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			4		B151022			
					144478			4					
D4016-5 *D4016-5* Hinge Half, Light Lid		Manufactured	No			100	Each	16.0000	3	3		DEC 20 2016	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			16		B152120			
					137225			16					

Picklist Print

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Work Order ID: 146503

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Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 5/18/2016

Required Date: 6/1/2016

Start Qty: 1.00

Required Qty: 1.00

D4019-3 Manufactured No

100 Each 6.0000 3 3

D4019-3

Rib

**

DEC 20 2016

Location

Loc Qty

Loc Code

WA004

6 B146408 → (3x)

144402

6

D4035-047 Manufactured No

100 Each 4.0000 2 2

D4035-047

Lid Rib Assembly, Aft (Light)

**

DEC 20 2016

Location

Loc Qty

Loc Code

WA004

4 B149890 → (2x)

144403

4

D4056-1 Manufactured No

100 Each 11.0000 1 1

D4056-1

Label Plate

**

DEC 20 2016

Location

Loc Qty

Loc Code

WA004

11

120216

11

D2728-1 Manufactured Yes

180 Each -2.0000 1 1

D2728-1

Dart Logo Label Small

**

(x1) 12/01/06

D4029-041 Manufactured No

180 Each 4.0000 1 1

D4029-041

Webbing (Long Basket)

**

DAS
6
9-89

JAN 04 2017

Location

Loc Qty

Loc Code

ST498A

4

144163

4

149654

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Shop Packet Print

Page 2

Picklist Print

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146503

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 5/18/2016

Required Date: 6/1/2016

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W4

Purchased

No

180

Each

1,528.000

34

34

MS20600-AD4W4

Rivets

Handwritten:
17-01-04 3

Handwritten:
DAS 6 JAN 04 2017
9-89

Location

Loc Qty

Loc Code

CCK005

1482

M133990

1482

Handwritten: 135603

ST308

46

M132640

46

NAS1149DN949J

Purchased

No

180

Each

208.0000

34

34

NAS1149DN949J

Washer

Handwritten:
DAS 6 JAN 04 2017
9-89

Location

Loc Qty

Loc Code

ST265

208

m133483

8

m134567

200

Handwritten: 34

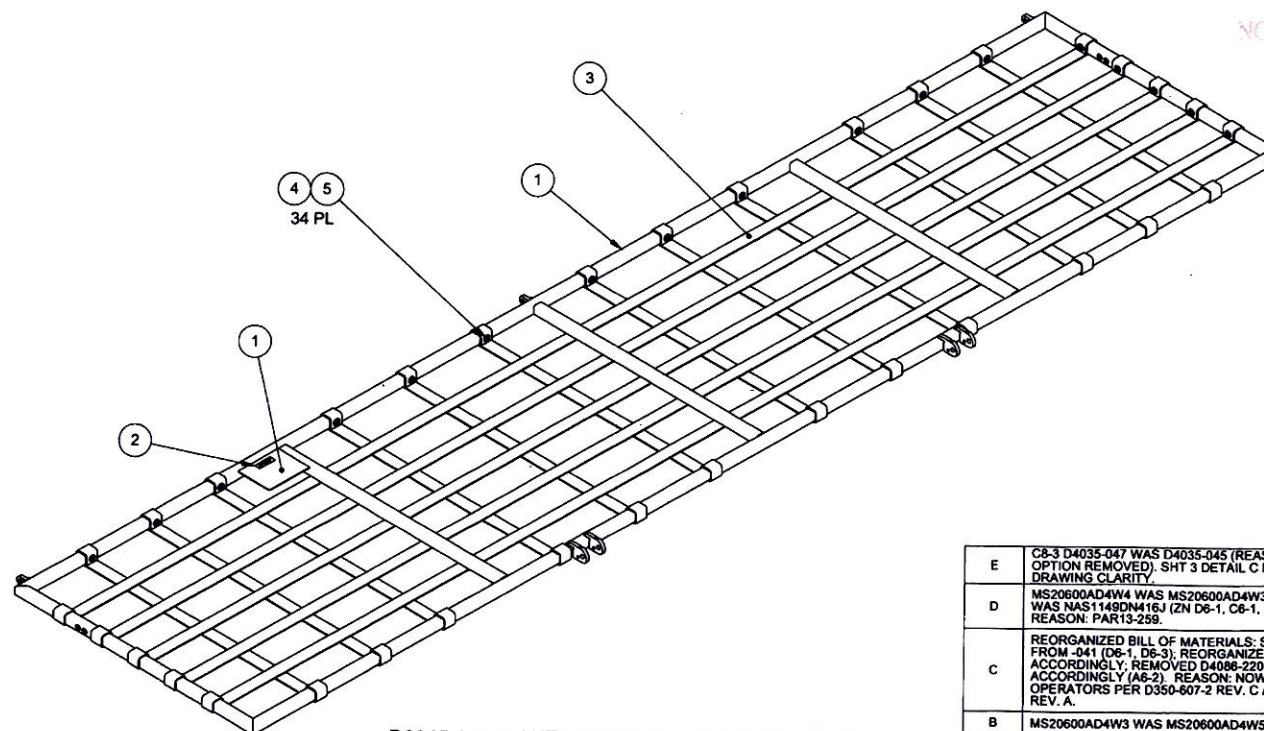
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	NAS1149DN949J	WASHER
5	34	MS20600AD4W4	RIVET, BLIND, PAN-HEAD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO 146503 MJS

16-05-18



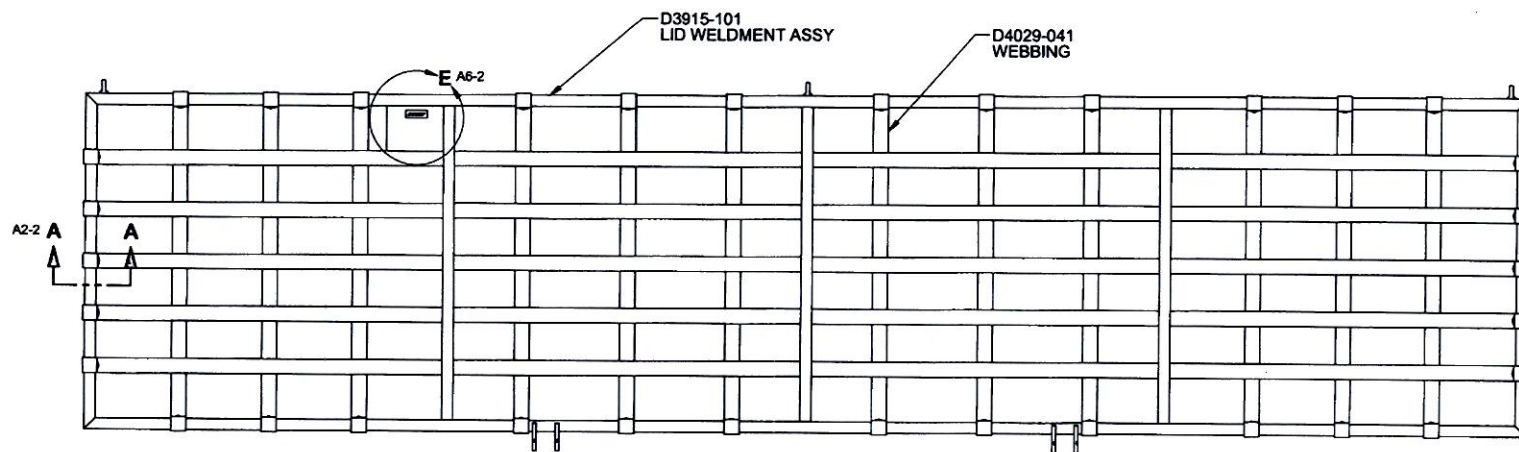
D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

RELEASED
2013-08-16

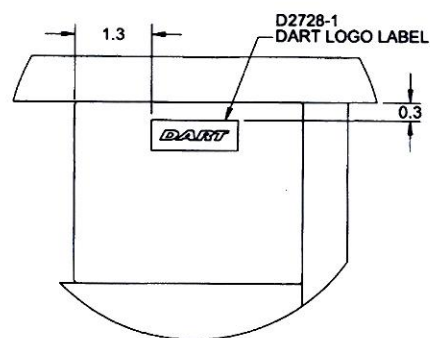
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.98 lbs

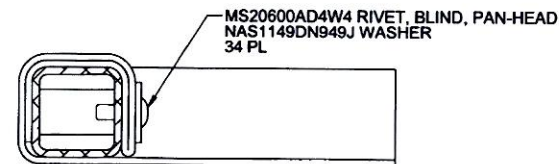
E	C8-3 D4035-047 WAS D4035-04S (REASON PROPARM OPTION REMOVED). SHT 3 DETAIL C DELETED FOR DRAWING CLARITY.	AJS	13.07.18
D	MS20600AD4W4 WAS MS20600AD4W3; NAS1149DN949J WAS NAS1149DN416J (ZN D6-1, C6-1, B1-2). REASON: PAR13-289.	MB	13.06.19
C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	up	DRAWING NO.	REV. E
MFG. APPR.	MA	D3915	SHEET 1 OF 4
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	LIGHT LID ASSY-LONG BASKET	Nts
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3915-041 LIGHT LID ASSY, LONG BASKET



DETAIL E D6-2

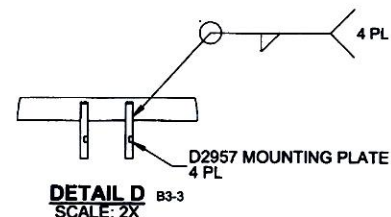
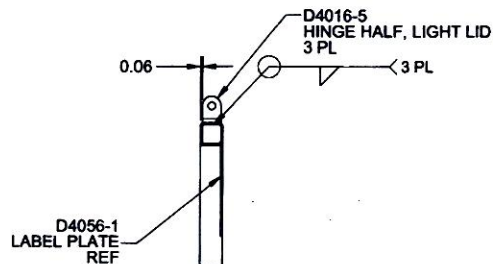


SECTION A-A C8-2
SCALE: 8X

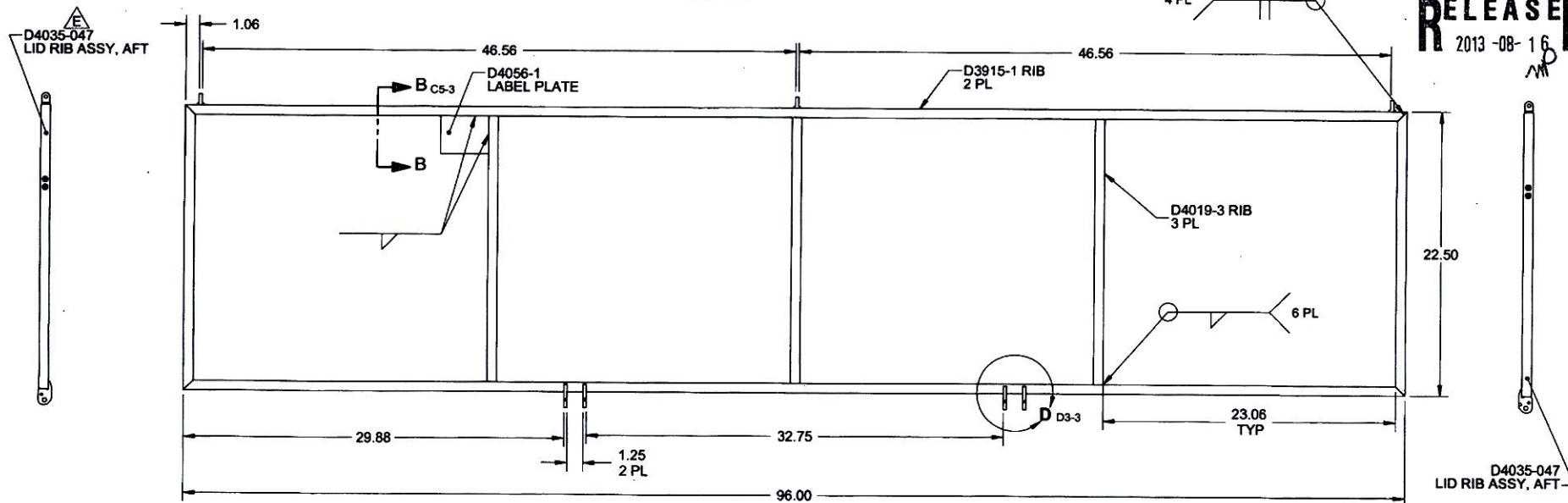
RELEASED
2013-08-16

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	4/1	DRAWING NO.	REV. E
MFG. APPR.		D3915	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	Nts
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	2	D3915-1	RIB
2	4	D2957	MOUNTING PLATE
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	2	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
6	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



SECTION B-B C6-3
SCALE: 2X



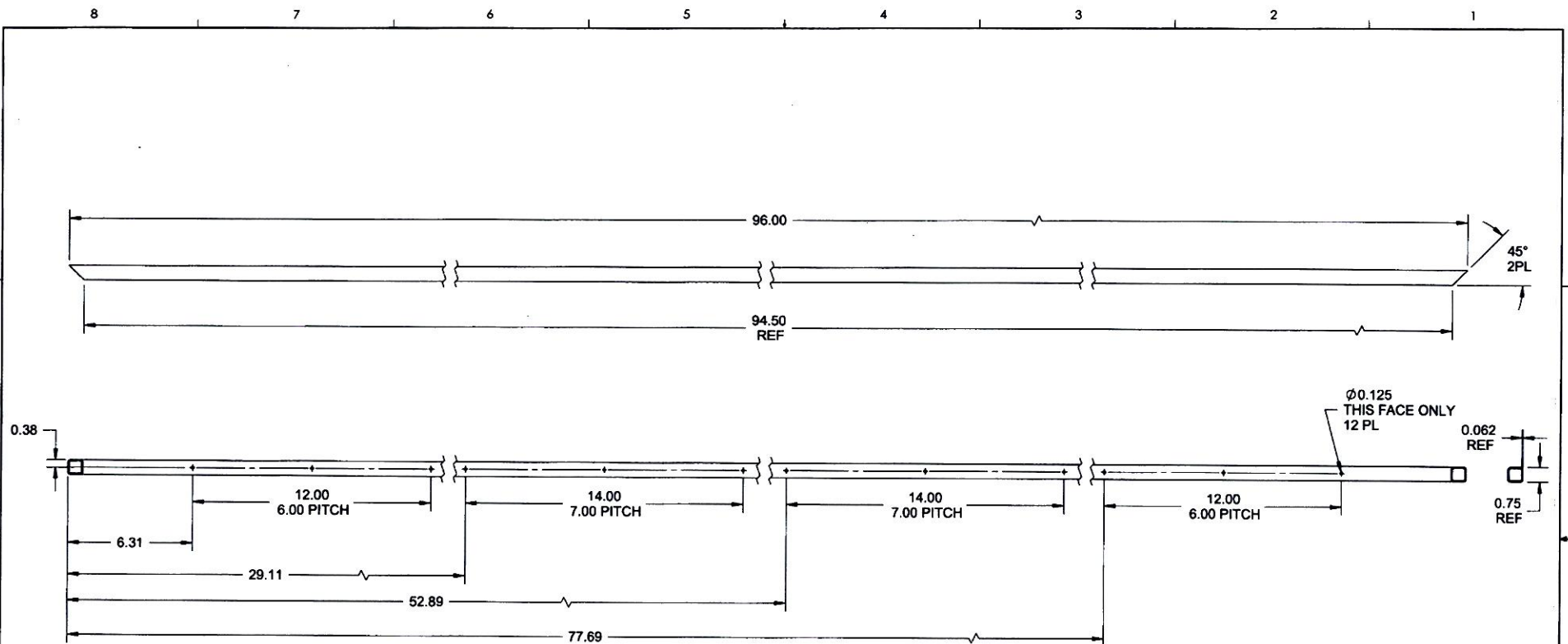
D3915-101 BASKET LID WELDMENT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.82 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3915	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2013-08-16



D3915-1 RIB

RELEASED
2013-08-16

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.49 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3915	REV. E
MFG. APPR.		SHEET 4 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	
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